

# Work Order ID 82903

Tuesday, April 10, 2012 2:48:02 PM

**\*82903\***

Page 1

Item ID: D3686-041

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: MONOPOD ASSEMBLY

Start Date: 4/10/2012 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 4/13/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference: REWORK

Approvals: Process Plan: *MF*

Date: *12-04-10*

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D3686

E

150

0.00

**\*150\***

QC

Memo

0.00

Quality Control

PULL FROM STOCK D3686-041 X 1 B78054

ON THE END, WRONG SCREWS WERE INSTALLED

*5/12/10*

*(K)*

160

0.00

**\*160\***

Small Fab

Memo

0.00

Small Fab

REMOVE AND DISCARD

REPLACE WITH:

MS21250-03014 X 2 B *M119902*

MS21042-3 X 2 B

PER DRAWING D3686-041 *M114597*

*(1)*

*FF 12/04/10*

# Picklist Print

Tuesday, April 10, 2012 2:48:01 PM

Page 1

Work Order ID: 82903  
Parent Item: D3686-041  
Parent Item Name: MONOPOD ASSEMBLY

Start Date: 4/10/2012

Required Date: 4/13/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A new issue 08-02-12 DD verified by:JLM  
IPP Rev:B As per Rev B 09-01-07 JLM Verified By:EC  
03-16 JLM VERIFIED BY:EC  
IPP Rev:D Added scalant note as per Rev C 09-01-20 JLM  
Verf:DD  
revE DD verf:EC  
IPP REV:C AS PER REV D 10-  
IPP REV:E 11.12.05 as per dwg

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3686-041 MONOPOD ASSEMBLY		Manufactured	No				Each	1.0000		1			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST077		1							
				77303		1							
MS21042-3 USE MS21042L3		Purchased	No				Each	2.0000		2			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST299		2							
				114597		2							
MS21250-03014 BOLT		Purchased	No				Each	16.0000		2			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST305		16							
				119902		6							
				121283		10							

1 x 78031 MF 12-04-13  
FF 12/04/10  
2  
2  
2  
FF 12/04/10

# Work Order ID 78054

December-28-11 9:18:42 AM

\*78054\*

482903

Page 1

Item ID: D3686-041

Accept

\*N900040100\*

Setup Start

\*NS1\*

Revision ID:

Item Name: MONOPOD ASSEMBLY

Stop

\*NS2\*

Start Date: 12/28/11 Start Qty: 1.00

\*1\*

Cust Item ID:

REFERENCE ONLY

Required Date: 12/28/11 Req'd Qty: 1.00

\*1\*

Customer:

Reference: disassemble

Approvals: Process Plan: W

Date:

Tooling:

Date:

Run Start

\*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop

\*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D3686

E

110

0.00

\*110\*

Small Fab

Small Fab

Memo

0.00

Small Fab

PULL FROM STOCK:  
1 X D3686-041 B67923  
REMOVE ROD END BEARING  
D3693-3 B50723  
RETURN TO STK FOR S/O106743 n

REPLACE WHEN AVAILABLE

D3693-3 B 77720

1- Use anti-seize compound Tectly 502c Class 1, Mil-PRF-16173E or equivalent on thread and assemble as per dwg D3686

\*\*\*\*\*ENSURE THERE IS ANTI-SEIZE ON FULL LENGTH OF THREAD\*\*\*\*\*

A/R Anti-Seize Batch: 111791

2- Assemble D3693-1 & D3691-1 & D3693-3 & D3688-7 Using Sikaflex -241/-291 between mating surfaces as per Dwg D3686

\*\*\*Ensure holes for AN3C Bolts are free of sealant.

Torque Fastners as per Dwg D3686\*\*\*

A/R Sikaflex Batch: 1119508

EF 11/2/28 ①

88 / FF 12-01-27

88 / FF 12-01-27

88 / FF 12-01-27

Work Order ID 78054

\*78054\*

Page 2

December-28-11 9:18:42 AM

Item ID: D3686-041

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: MONOPOD ASSEMBLY

Start Date: 12/28/11 Start Qty: 1.00

\*1\*

Cust Item ID:

Required Date: 12/28/11 Req'd Qty: 1.00

\*1\*

Customer:

Reference: disassemble

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start \*NR1\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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120 QC5- Inspect part completeness to step on W/O

0.00

\*120\*

12/26/27

QC

QC

Memo

0.00

Quality Control

130 Identify as per dwg & Stock Location *SI 178* 0.00

\*130\*

SP 12-01-27

Packaging

Memo

0.00

Packaging

RE-IDENTIFY USING NEW B/N

140 QC21- Final Inspection - Work Order Release 0.00

\*140\*

12/2/11

QC

Memo

0.00

Quality Control

12-01-31

# Picklist Print

December-28-11 9:18:42 AM

Page 1

Work Order ID: 78054  
Parent Item: D3686-041  
Parent Item Name: MONOPOD ASSEMBLY

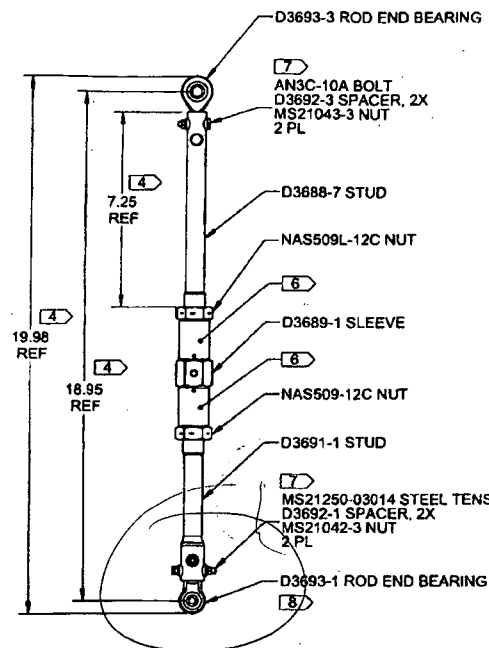
Start Date: 12/28/11 Required Date: 12/28/11  
Start Qty: 1.00 Required Qty: 1.00

Comments: IPP Rev:A new issue 08-02-12 DD verified by:JLM  
IPP Rev:B As per Rev B 09-01-07 JLM Verified By:EC  
03-16 JLM VERIFIED BY:EC  
IPP Rev:D Added sealant note as per Rev C 09-01-20 JLM  
Verf:DD  
revE DD verf:EC  
IPP REV:C AS PER REV D 10-  
IPP REV:E 11.12.05 as per dwg

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3686-041 MONOPOD ASSEMBLY		Manufactured	No				Each	2.0000		1	67923	12	
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				ST077		2							
				77303		2							
D3693-3 Rod End Bearing		Manufactured	No				Each	0.0000		1	FF	12-01-27	
D3693-3 Rod End Bearing		Manufactured	No				Each	0.0000		-1	FF	12-01-27	

AN3C10A  
D3692-1  
MS 21043-3  
112489  
m 104423  
B 73232  
m 119901  
(2x)  
(4x)  
(4x)  
FF 12-01-27  
FF 12-01-27  
FF 12-01-27

ITEM	QTY -041	PART NUMBER	DESCRIPTION
1	X	D3688-041	MONOPOD ASSEMBLY
2	1	D3688-7	STUD
3	1	D3689-1	SLEEVE
4	1	D3691-1	STUD
5	4	D3692-1	SPACER
6	4	D3692-3	SPACER
7	1	D3693-1	ROD END BEARING
8	1	D3693-3	ROD END BEARING
9	2	AN3C-10A	BOLT
10	2	MS21042-3	NUT
11	2	MS21043-3	NUT
12	2	MS21250-03014	STEEL TENSION BOLT
13	1	NAS509L-12C	NUT
14	1	NAS509-12C	NUT



**D3688-041 MONOPOD ASSEMBLY**

**NOTES:**

- 1) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) UNITS: INCHES UNLESS OTHERWISE NOTED
- 3) IDENTIFICATION: IDENTIFY WITH DART ASSEMBLY P/N D3688-041 USING FINE POINT PERMANENT INK MARKER
- 4) DIMENSIONS SHOWN ARE WHEN D3688-7 & D3691-1 STUDS ARE FULLY THREADED INTO D3689-1 SLEEVE
- 5) WEIGHT: 3.0 lbs
- 6) USE TECTYL 502C CLASS I, MIL-PRF-16173E GRADE 2 OR EQUIVALENT ANTI-SEIZE COMPOUND ON THREAD
- 7) TORQUE FASTENERS TO 20-25 in-lbs
- 8) ASSEMBLE D3693-1 WITH D3691-1 & D3693-3 WITH D3688-7 USING SIKAFLEX-241/291 OR PROSEAL 890 OR MIL-S-8802 CLASS 'B2' SEALANT BETWEEN MATING SURFACES. ENSURE HOLES FOR AN3C BOLTS ARE CLEAR OF SEALANT

E	QTY(2) MS21250-03014 STEEL TENSION BOLTS AND QTY(2) MS21042-3 NUT REPLACE QTY(2) AN3C12A BOLTS AND QTY(2) MS21043-3 NUT (ZN B3-1 & C9D6-1) REASON: PRODUCT IMPROVEMENT (REF. NCRI11784)	MB	11.11.23
D	19.98 WAS 20.10 (ZN C8-1); 18.95 WAS 19.07 (ZN C8-1)	RF	10.03.03
C	ROD END BEARINGS NOW ASSEMBLED USING SEALANT (ZN A8-1, B4-1)	RF	08.12.15
B	REFORMATTED TO CURRENT DWG STANDARDS	RF	08.11.24
A	NEW ISSUE	RF	08.05.22
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	11.11.23		

**DART AEROSPACE LTD**  
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3686** REV. E  
SHEET 1 OF 1  
TITLE **MONOPOD ASSEMBLY** SCALE NTS

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**RELEASED**  
2011-12-01

# Picklist Print

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Tuesday, April 05, 2011 9:58:05 AM

Work Order ID: 67923

Parent Item: D3686-041

Parent Item Name: MONOPOD ASSEMBLY

Start Date: 4/4/2011

Required Date: 4/8/2011

Start Qty: 2.00

Required Qty: 2.00

D3692-3 Manufactured No

110 Each 23.0000

4 8



SS 11/07/04

(2)

SPACER

Location

Loc Qty

Loc Code

ST075

23

44690

23

110 Each 22.0000

1

2

D3693-1

Manufactured No



SS 11/07/04

(2)

Rod End Bearing

Location

Loc Qty

Loc Code

GA

22

50734

22

110 Each 2.0000

1

2

D3693-3

Manufactured No



SS 11/07/04

(2)

Rod End Bearing

Location

Loc Qty

Loc Code

GA

2

50723

2

110 Each 28.0000

2

4

AN3C10A

Purchased No



SS 11/07/04

(2)

Bolt

Location

Loc Qty

Loc Code

ST351

28

105940

8

112489

20

110 Each 41.0000

2

4

AN3C12A

Purchased No



SS 11/07/04

(2)

Bolts

Location

Loc Qty

Loc Code

ST351

41

116924

41

1117794

(2)

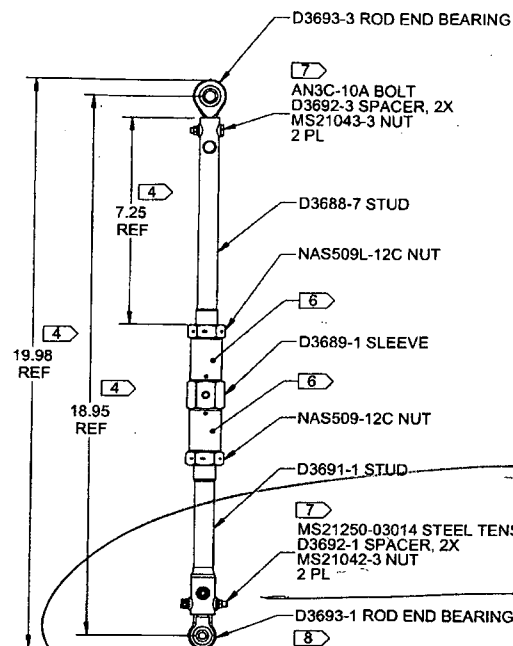
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Tuesday, April 05, 2011 9:58:06 AM

Shop Packet Print

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ITEM	QTY	PART NUMBER	DESCRIPTION
1	X	D3686-041	MONOPOD ASSEMBLY
2	1	D3688-7	STUD
3	1	D3689-1	SLEEVE
4	1	D3691-1	STUD
5	4	D3692-1	SPACER
6	4	D3692-3	SPACER
7	1	D3693-1	ROD END BEARING
8	1	D3693-3	ROD END BEARING
9	2	AN3C-10A	BOLT
10	2	MS21042-3	NUT
11	2	MS21043-3	NUT
12	2	MS21250-03014	STEEL TENSION BOLT
13	1	NAS509L-12C	NUT
14	1	NAS509-12C	NUT



**D3686-041 MONOPOD ASSEMBLY**

**NOTES:**

- 1) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
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- 5) WEIGHT: 3.0 lbs
- 6) USE TECTYL 502C CLASS I, MIL-PRF-16173E GRADE 2 OR EQUIVALENT ANTI-SEIZE COMPOUND ON THREAD
- 7) TORQUE FASTENERS TO 20-25 in.-lbs
- 8) ASSEMBLE D3693-1 WITH D3691-1 & D3693-3 WITH D3688-7 USING SIKAFLEX-241/291 OR PROSEAL 890 OR MIL-S-8802 CLASS 'B2' SEALANT BETWEEN MATING SURFACES. ENSURE HOLES FOR AN3C BOLTS ARE CLEAR OF SEALANT

E	QTY(2) MS21250-03014 STEEL TENSION BOLTS AND QTY(2) MS21042-3 NUT REPLACE QTY(2) AN3C12A BOLTS AND QTY(2) MS21043-3 NUT (ZN B3-1 & C5/D6-1). REASON: PRODUCT IMPROVEMENT (REF. NCR11-784)	MB	11.11.23
D	19.98 WAS 20.10 (ZN C8-1); 18.95 WAS 19.07 (ZN C5-1)	RF	10.03.03
C	ROD END BEARINGS NOW ASSEMBLED USING SEALANT (ZN A8-1, B4-1)	RF	08.12.15
B	REFORMATTED TO CURRENT DWG STANDARDS	RF	08.11.24
A	NEW ISSUE	RF	08.05.22
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>[Signature]</i>	<b>DART AEROSPACE LTD</b>	
DRAWN	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. E
MFG. APPR.	<i>[Signature]</i>	<b>D3686</b>	SHEET 1 OF 1
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	<b>MONOPOD ASSEMBLY</b>	NTS
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